

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-011411**Date Inspected:** 16-Jan-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Joe Alaniz was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

OBG Assembly Yard

6BW+6CW

Shield Metal Arc Welding (SMAW) welding was performed on weld joints 013 and 014 located at EP041-001 cross beam side of segment. Welder is identified as Mr. Li Wenguo (220066). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2214-B-U2-FCM-1.

5CE

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 006 located at CA024 on bike path side of segment. Welder is identified as Mr. Wang Li (044772). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS345-SMAW-4G (4F)-FCM-1 and CWR #1075 repair procedure.

Y Location of repairs areas by above noted welder (044772) is located between 10615mm~10600mm.

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5AE

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 004 located at CA018 bike path side of segment. Welder is identified as Mr. Sun Lingling (048047). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS345-SMAW-2G (2F)-FC-Repair-1 and CWR #1089 repair procedure.

Y Location of repairs areas by above noted welder (048047) is located at 7580mm.

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 004 located at CA018 bike path side of segment. Welder is identified as Mr. Wu Haijun (201087). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS345-SMAW-2G (2F)-FC-Repair-1 and CWR #1089 repair procedure.

Y Location of repairs areas by above noted welder (201087) is located between 10640mm~10850mm.

5BW

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 005 located at SEG023A bike path side of segment. Welder is identified as Mr. Du Hengyou (037743). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS345-SMAW-1G (1F)-FC-Repair-1 and CWR #1074 repair procedure

6CW

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 005 located at SEG023A counter weight side of segment. Welder is identified as Mr. Bi Shijian (068764). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2214-Tc-U4b-FCM-1.

6BW

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 005 located at CA027 counter weight side of segment. Welder is identified as Mr. Bi Shijian (068764). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2214-Tc-U4b-FCM-1.

NDT Observation

This QA Inspector observed ZPMC Magnetic Particle (MT) Technician performing MT on various locations in the trial assembly yard. Locations are as followed:

5BE

1. Excavation areas on edge to deck plate weld on bike path side of segment. Y locations of excavations and numbers of MT Indications observed are as followed:

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Y locations are 8190mm~8200mm (2 transverse cracks) and 10275mm (4 transverse cracks).

5AE

1. Excavation areas on edge to deck plate weld on cross beam side of segment. Y locations of excavations and numbers of MT Indications observed are as followed:

Y locations are 7260, 10700mm (2 transverse cracks), 11385mm (2 transverse cracks) and 13150mm (4 transverse cracks).

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (134-8257-0045), who represents the Office of Structural Materials for your project.

Inspected By:	Alaniz,Joe	Quality Assurance Inspector
Reviewed By:	Miller,Mark	QA Reviewer
